

Date: Thursday, 10/04/2008 4:00:46 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
 Job Number : 38544  
 Estimate Number : 10265  
 P.O. Number :  
 This Issue : 10/04/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D350636012  
 First Issue : / / Type : LANDING GEAR Drawing Number : D2750 REV E  
 Previous Run : 38407 Drawing Revision : E  
 Material :  
 Due Date : 05/05/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JO 08.4.10  
 Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ  
 Est Rev:J 06-03-29 As per Rev D EC  
 Est Rev:K 06-07-13 As per dsi9343 EC  
 Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM  
 Verified By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
 Photocopy blue file and type labels per PPP D350-636-012 CHG 003

08/04/30 08.4.22 JLD

2.0 D26003BENT



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B37758

① M 8-4-16

3.0 D2744



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Cap

Batch: B39996 BE 08/04/16

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut

M  
8-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #: Machine Or Operation: Description :

as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

\*\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod *m106330 BE 08/04/16*

10-Grind welds flush as per Dwg D2750

VISUAL INSPECTION OF GROUND WELDS

5.0

QC10



Comment: VISUAL INSPECTION OF GROUND WELDS

*08/04/17 (42)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/04/17 (40)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*4T 08.04.17*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DP 8-4-17*

9.0

D2739



Comment: Qty.: 1.00000 Each(s)/Unit Total: 1.00000 Each(s)

Web

Batch:

*B38099*

*DK 8-4-17*

W/O:		WORK ORDER CHANGES					
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Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0

D34901



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Crossbolt spacer

Batch: *B 33824*

*RF 08/04/22*

11.0

D34903



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Crossbolt spacer

Batch: *B 33825*

*RF 08/04/22*

12.0

D2743



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

Crossbolt Spacer

Batch: *B 36030*

*RF 08/04/22*

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: *M 107397*  
exp. date: *8-10-1*

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 4)

*M*  
*8-4-7*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #: Machine Or Operation: Description :

A/R Aluminum Rod

batch: *m 107263*

*BE 08/04/22*

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

*98-422*

11-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*C 08/04/22 (41)*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*C 08/04/22 (40)*

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

*BR 08-04*

*338544  
D35063012  
24/04/2008*

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*JP M07530*

*HU 08-04*

*S.105  
#1 11.44  
#2 321.6  
#3 30m108  
#4*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*BR 08-04-24*

19.0

ALS41032225



Comment: Qty.: 42.00000 Each(s)/Unit Total : 42.00000 Each(s)

Insert

Batch: *m 100621*

*BR*

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

*BR 08-04-24  
BR 08-04-24*

W/O:		WORK ORDER CHANGES					
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Job Number: 38544

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D2745	
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Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

Bushing

Batch: B34817 B37303 BR

22.0	D353513	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

WEARSHOE

Batch: B37584 BR

23.0	D353525	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

WEARSHOE

Batch: B37898 BR

24.0	D353535	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

WEARSHOE

Batch: B37625 BR

25.0	D353613	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

GASKET

Batch: B36635 BR

26.0	D353625	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

GASKET

Batch: B36636 BR

27.0	D353635	
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Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

GASKET

Batch: B38183 BR

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Job Number: 38544

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0

D35371



Comment: Qty.: 5.00000 Each(s)/Unit Total : 5.00000 Each(s)

WEARPAD

Batch:

~~B 34919~~ B 34903 B 36426 BR. 08-04-29

29.0

D36311



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

WASHER

Batch:

B 38139

BR

30.0

D3488042



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Blade Fitting, RH

Batch:

B 35587

BR

31.0

D3492041



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

PLUG ASSEMBLY

Batch:

B 36902

BR

32.0

D3492043



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

PLUG ASSEMBLY

Batch:

B 36237

BR

33.0

AN3C5A



Comment: Qty.: 38.00000 Each(s)/Unit Total : 38.00000 Each(s)

Bolt

Batch:

B 106780

BR

34.0

AN3C6A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Bolt

Batch:

B 105300

BR

BR 08-04-24 D.

W/O:		WORK ORDER CHANGES					
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Job Number: 38544

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0

AN3C7A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

BOLT

Batch: M107906

BR

36.0

AN6C44A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

BOLT

Batch: M107314

BR

37.0

AN8C35A



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

BOLT

Batch: M102671

BR

38.0

AN960C10L



Comment: Qty.: 46.00000 Each(s)/Unit Total : 46.00000 Each(s)

washer

Batch: M107376

BR

39.0

AN960C816L



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: M106513

BR

40.0

MS210436



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

NUT

Batch: M107736 (2)

M103693

BR

41.0

MS21083C8



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

NUT

Batch: M1006431

BR

BR 08-04-24

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38544

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

NAS1515H3L



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

WASHER

Batch: M 106516

BL

43.0

NAS1515H8L



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: M 107581

BL

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M 105005

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2730

SIKA FLEX 241

BATCH: M 107804

EXP DATE: 08-10

4-Coat all exposed fasteners with "LPS Procyon"

batch: M 104251

BL 08-04-24 (D)

BL 08-04-29 (D)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/29 (D)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D2741



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Blade

Batch: B36343

AS 08/04/29 (XO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 38544

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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48.0	AN960C816L	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

Washer

Batch: M107520

49.0	MS21083C8	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

Nut

Batch: M107650

50.0	AN8C21A	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

Bolt

Batch: M107596

51.0	NAS1515H8L	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: M107581

52.0	D34931	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

WASHER

Batch: B38102

53.0	D35321	
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Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)

spacer

Batch: B33085

54.0	QC4	
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Comment: INSPECT 100% KITS FOR COMPLETENESS

INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
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Seq. #:

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Description :

55.0

PACKAGING 1

PACKAGING RESOURCE #1



(14)

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev F

8/4/30

SEP

56.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-01

38544

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**DART****RELEASED**  
07.08.02

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 1 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

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**DART**

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DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS

GENERAL NOTES:**RELEASED**  
*07-08-02 [Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESSIVE POWDER COATING WITH MEK DEGREASER.

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NO. 143

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Darclay E  
Joint Welding Procedure GTAW  
Part number and Job number D350636 04 / B37279

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS TIG  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

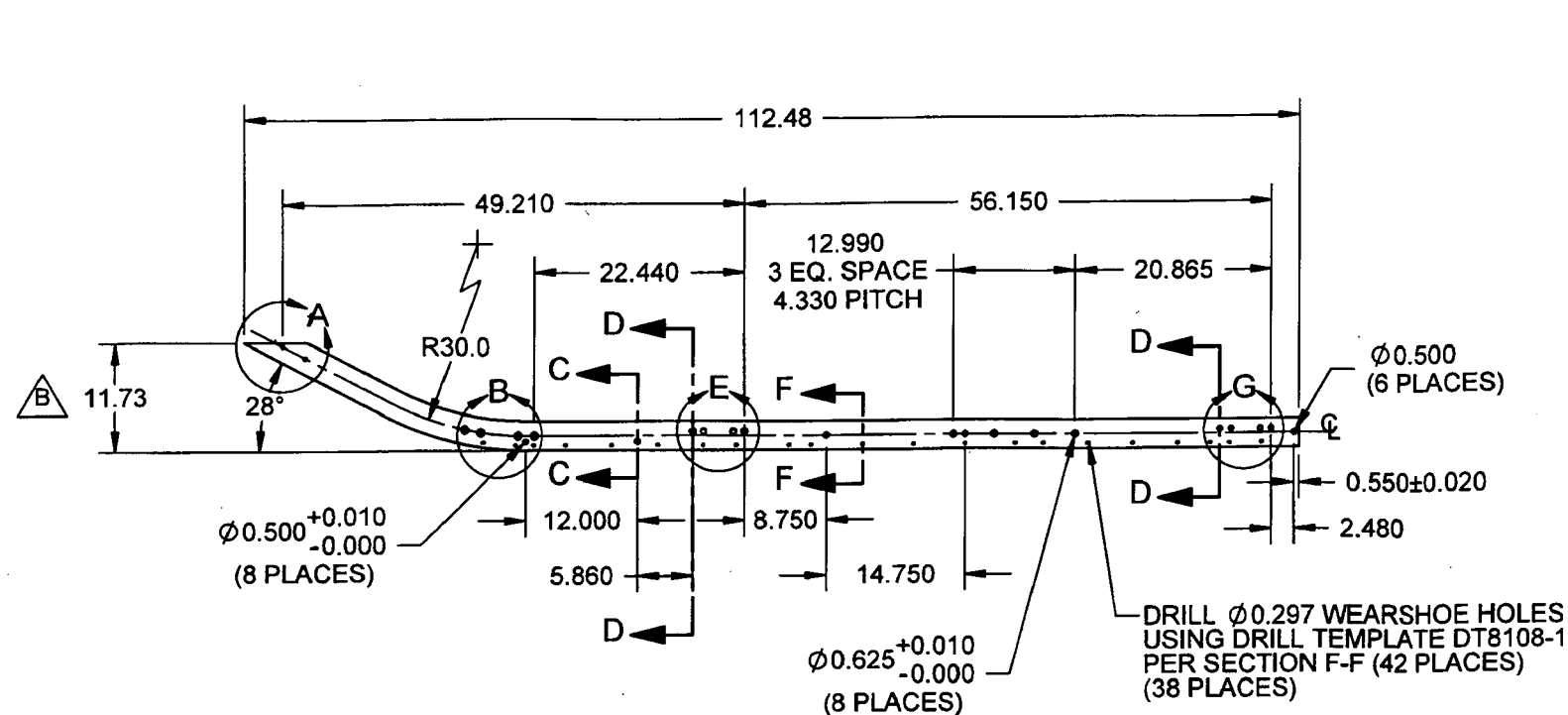
Crossbolt Spacer Welded into NA Skidtube

TEST RESULTS

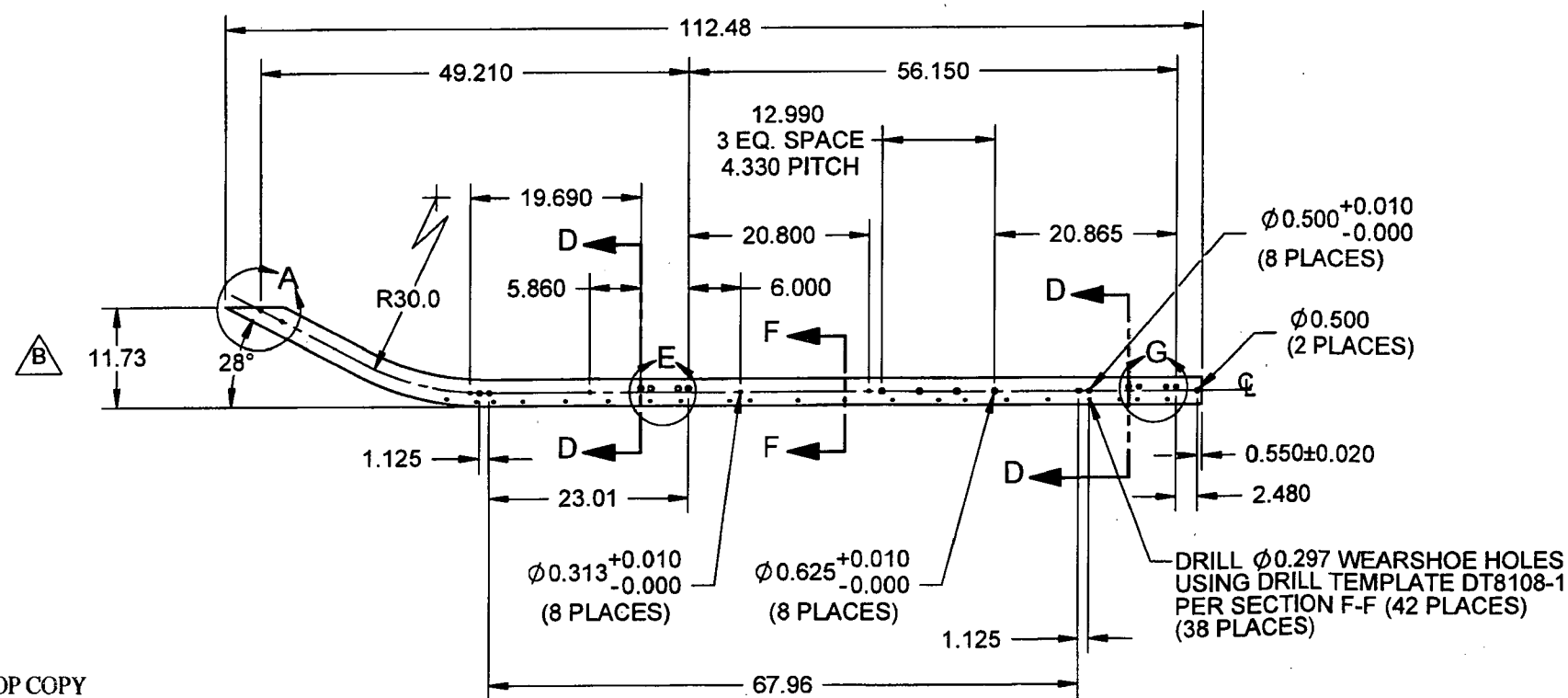
Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

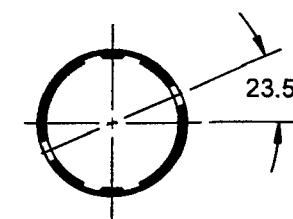
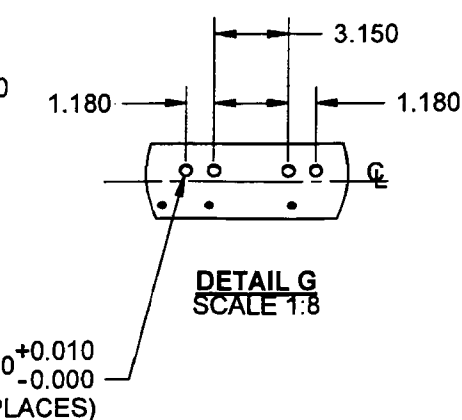
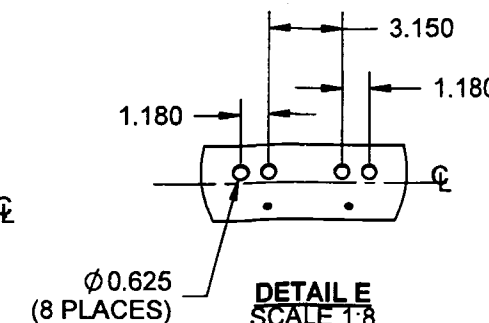
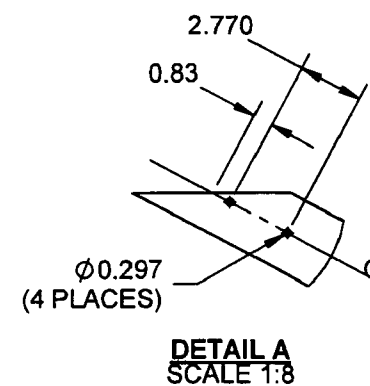
Date of Test Coupon 08-03-06 Qualifier Pat Diwal



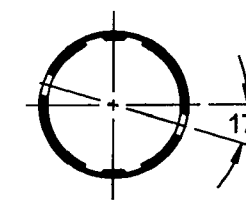
**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



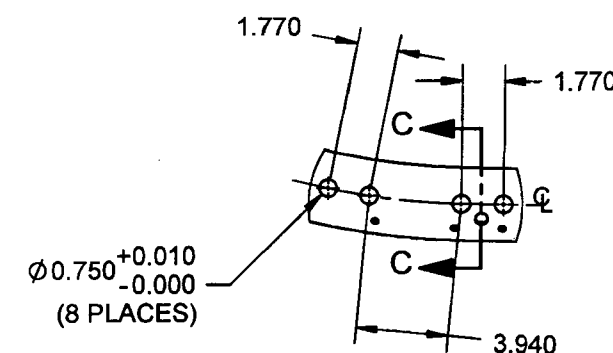
**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



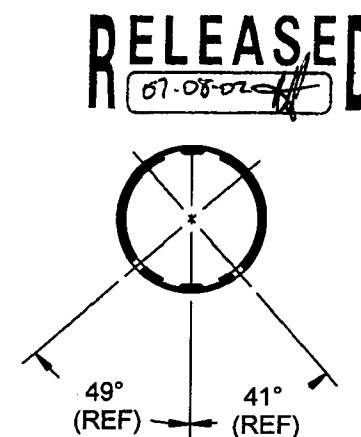
**SECTION C-C**  
**SCALE 1:4**



**SECTION D-D**  
**SCALE 1:4**



**DETAIL B**  
**SCALE 1:8**  
**(ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)**



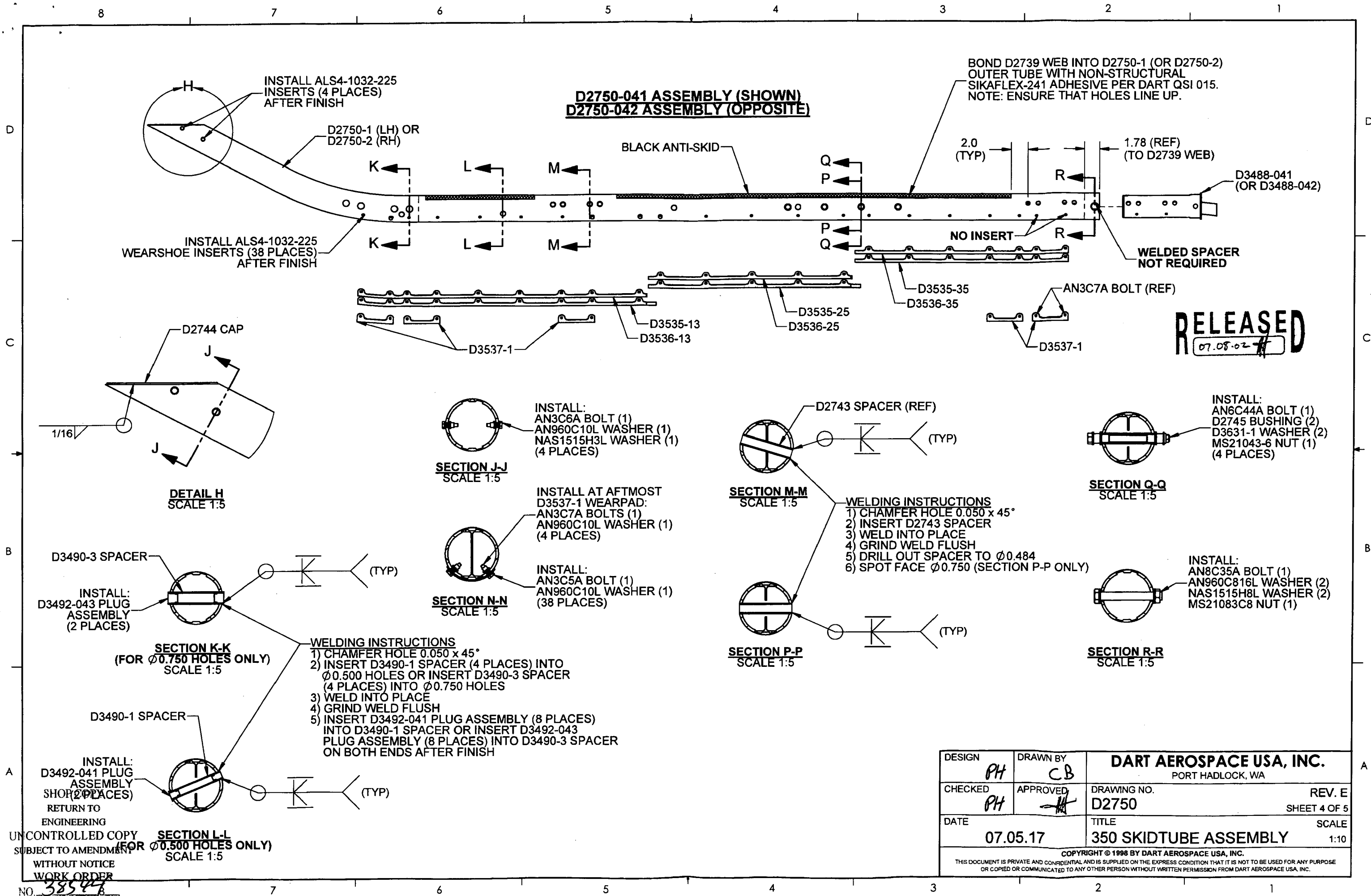
**SECTION F-F**  
**SCALE 1:4**

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07-08-02

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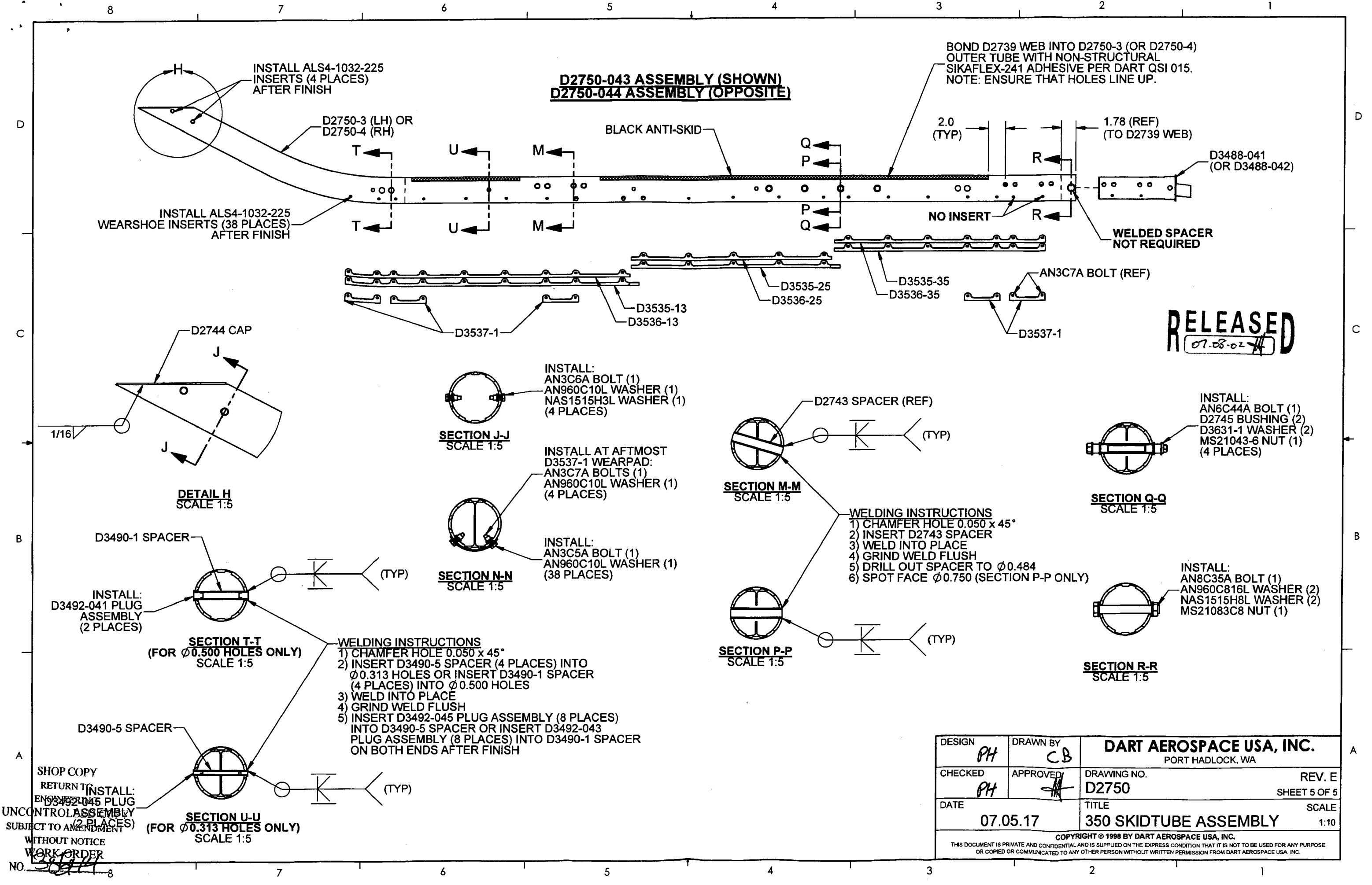




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